

Patent Claims:

1. Piston unit having a captive spring (9) for a cylinder, in particular a tandem master cylinder of a motor vehicle, wherein the spring (9), with a first end (14), is supported at least indirectly on a piston (1) and, with a second end (15), is supported on a retaining device (8) that is displaceable relative to the piston (1) and the movement of which relative to the piston (1) is limited by securing means (3, 4),
c h a r a c t e r i z e d in that the securing means (3, 4) include a projection (3) that is non-detachably arranged at the piston (1) and whose free end (16) is provided with a stop (4) that limits the movement of the retaining device (8) relative to the piston (1).
2. Piston unit as claimed in claim 1,
c h a r a c t e r i z e d in that the projection (3) is formed integrally with the piston (1), preferably by extrusion.
3. Piston unit as claimed in claim 1 or 2,
c h a r a c t e r i z e d in that the stop (4) is fastened to the piston (1) in a form-fit.
4. Piston unit as claimed in claim 3,
c h a r a c t e r i z e d in that the projection (3) is cylindrical and includes a step (18) for abutment of a disc (4) at least in the area of the free end (16).

5. Piston unit as claimed in claim 4,
c h a r a c t e r i z e d in that the annular disc
riveted to the projection (3) forms the stop (4).
6. Piston unit as claimed in claim 5,
c h a r a c t e r i z e d in that the stop (4) is
fastened to the piston (1) by way of wobble-riveting.
7. Piston unit as claimed in claim 1 or 2,
c h a r a c t e r i z e d in that the stop (4) is
provided by deforming the free end (16) of the projection
(3).
8. Piston unit as claimed in any one of claims 1 to 7,
c h a r a c t e r i z e d in that the piston (1)
includes a bottom (10) and a bowl (2) projecting from it,
said bowl accommodating the spring (9) and the projection
(3) at least in part.
9. Piston unit as claimed in any one of claims 1 to 8,
c h a r a c t e r i z e d in that the piston (1) is
formed in an extrusion process and, on an outside surface
(19), includes recesses (13) used to accommodate a push
rod that moves the piston (1).